



slip 18/03

Date: Tuesday, 18/03/2008 7:26:50 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHIM
Job Number :	38074		
Estimate Number :	13188		
P.O. Number :		Part Number :	D37511
This Issue :	18/03/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3751 UNDER REVIEW REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	37486	Drawing Revision :	A B 18/03/17
Written By :		Material :	
Checked & Approved By :		Due Date :	18/03/2008
Comment :	Est Rev:A 08-01-30 new issue DD verified by: Qty: 10 Um: Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



.4



Comment: Qty.: 0.0311 sf(s)/Unit Total : 0.3108 sf(s)

6061t6 sheet .063" thick
(M6061t6s063)

Batch: 106370 B 8-3-18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3751

Dwg Rev: B

Prog Rev: B

B 8-3-18



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-3-18



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

18/03/18 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

18/03/18 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/03/2008 7:26:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 38074

Part Number: D37511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/18 (10)

PHG

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005

BR 08-03-18

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/3/18 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/3/18 (10)

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/18

Job Completion



u 580319



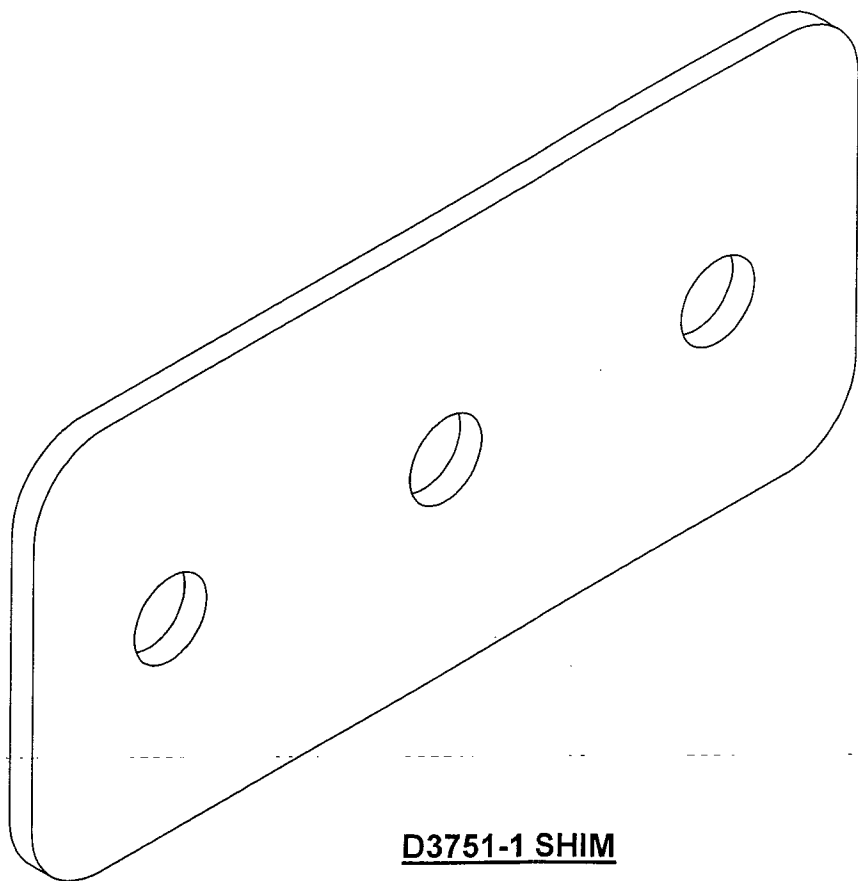
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/03/18	6.1	Chemical conversion Coat as per QSI 005 005 4.1	FL A	08/03/18 08/03/18			S 08/03/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3751-1 SHIM

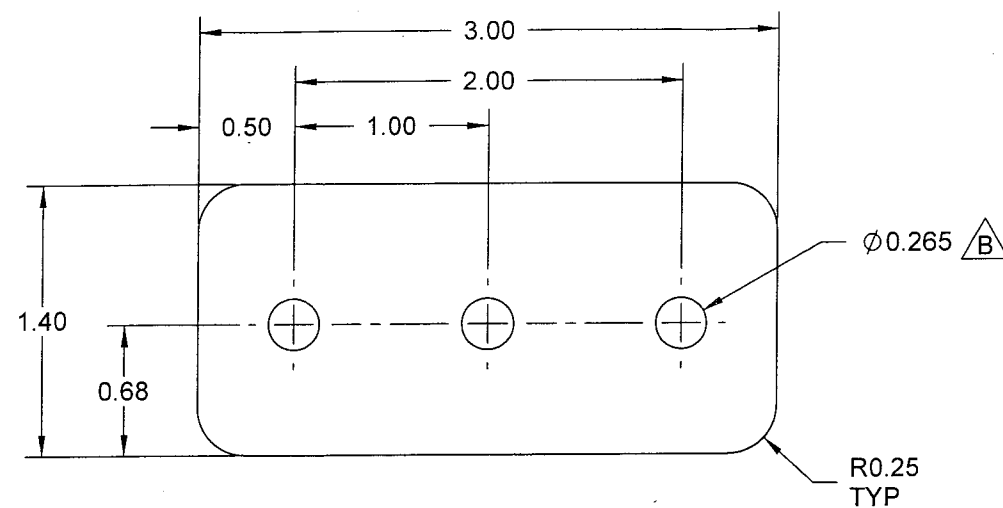
REFERENCE ONLY

RELEASED
08-03-17

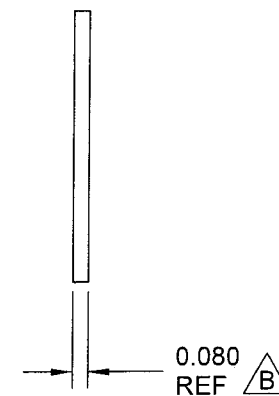
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY D3751-1 WITH DART P/N D3751-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

B	-3 SHIM DELETED. MATERIAL WAS 0.060 THICK. SHEET 2 ZONE C4 Ø0.265 HOLE WAS Ø0.193.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.11
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ASS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3751	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHIM	NTS
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D3751-1 SHIM



REFERENCE ONLY

RELEASED
08.03.17

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	ALP	D3751	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHIM	NTS
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